

Work Order ID 69792

Thursday, May 19, 2011 12:32:35 PM



Page 1

Ship today

Item ID: D407-802-011

Accept



Setup Start



Revision ID:

Stop



Item Name: Crew Door Opener Installation, LH

Start Date: 5/19/2011 Start Qty: 1.00



Cust Item ID:

Required Date: 5/19/2011 Req'd Qty: 1.00



Customer:

Reference:

Approvals: Process Plan: *CMF*Date: *11-05-11*

Tooling:

Date:

Run Start



QC: _____

Date: _____

SPC (Y/N): _____

Date: _____

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

Draw Nbr

Revision Nbr

IIN-D407-802-1

A

100

0.00



DOCUMENT CONTROL

DC

Memo

0.00

Document Control

Photocopy bluefile and create labels per PPP D407-802-011 CHG001

*8/15/11**N/A*

105

0.00



Pick Kit

Packaging

Memo

0.00

Packaging

11/5/11

110

0.00



QC4- 100% Inspect kits for completeness

QC

Memo

0.00

Quality Control

*8/15/11**(X)*

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Item ID: D407-802-011

Accept



Setup Start



Revision ID:

Stop



Item Name: Crew Door Opener Installation, LH

Start Date: 5/19/2011 Start Qty: 1.00



Cust Item ID:

Required Date: 5/19/2011 Req'd Qty: 1.00



Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
120		0.00							
	Packaging								
Packaging	Memo	0.00							
Packaging	Identify and pack for shipping as per PPPD407-802-011								
	Location: _____								
	PPP rev: _____								
130	QC21- Final Inspection - Work Order Release	0.00							
QC	Memo	0.00							
Quality Control									

PP 69788

ulsha sp

11/5/19

cmf
11-05-19

W/O:		WORK ORDER CHANGES					
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Required Qty: 1.00

IPP Rev:B

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D3552-15 		Manufactured	No			105	Each	29.0000	1	1			
Door Prop													
				<u>Location</u>									
				ST272				17					
					<u>64402</u>			17		1			
				ST272A				12					
					<u>65119</u>			12					
D3622-5 		Manufactured	No			105	Each	54.0000	2	2			
Ball Stud													
				<u>Location</u>									
				ST070				54					
					<u>64330</u>			14		2			
					<u>64428</u>			20					
					<u>65087</u>			20					
D4106-1 		Manufactured	No			105	Each	9.0000	1	1			
Sill Doublor, LH													
				<u>Location</u>									
				ST127				9					
					<u>62288</u>			2		1			
					<u>64331</u>			7					

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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Picklist Print

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Work Order ID: 69792



Parent Item: D407-802-011



Parent Item Name: Crew Door Opener Installation, LH

Start Date: 5/19/2011

Required Date: 5/19/2011

Start Qty: 1.00

Required Qty: 1.00

D4106-3

Manufactured No

105 Each

7.0000



1
SD



Crew Door Doulber, LH

Location

Loc Qty

Loc Code

ST127

7

62289

3

64333

4

1

D4106-5

Manufactured No

105 Each

20.0000



1
SD



Spacer, Sill Doulber

Location

Loc Qty

Loc Code

ST127

20

62296

4

64335

8

64341

8

1

D4106-7

Manufactured No

105 Each

13.0000



1
11/5/95



Template

Location

Loc Qty

Loc Code

ST127

13

62295

1

64336

12

1

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Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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Work Order ID: 69792

Parent Item: D407-802-011

Parent Item Name: Crew Door Opener Installation, LH

Start Date: 5/19/2011

Required Date: 5/19/2011

Start Qty: 1.00

Required Qty: 1.00

CR3523-4-02

Purchased

No

105

Each

335.0000

26



RIVET

Location

Loc Qty

Loc Code

ST312

232

116915

132

117291

100

ST313

103

116391

100

116893

3

CR3523-4-4

Purchased

No

105

Each

90.0000

4



Rivet

Location

Loc Qty

Loc Code

ST314

90

115768

90

CR3523-4-5

Purchased

No

105

Each

100.0000

3



Rivet

Location

Loc Qty

Loc Code

ST313

100

117423

100

CR3523-4-6

Purchased

No

105

Each

200.0000

8



Rivet

Location

Loc Qty

Loc Code

ST314

200

115768

100

116606

100

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W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
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Work Order ID: 69792

Parent Item: D407-802-011

Parent Item Name: Crew Door Opener Installation, LH

Start Date: 5/19/2011

Required Date: 5/19/2011

Start Qty: 1.00

Required Qty: 1.00

CR3523-4-07

Purchased

No

105

Each

169.0000

7

7



RIVET



5

Location

Loc Qty

Loc Code

ST313

169

116606

100

17768

69

MS20426AD4-5

Purchased

No

105

Each

5,782.000

4

4



Rivet



7
4

Location

Loc Qty

Loc Code

MEZZ

493

6733

493

ST317

5289

6874

5289

MS21073L5

Purchased

No

105

Each

147.0000

2

2



nut plate



11/5/11

Location

Loc Qty

Loc Code

ST302

100

117395

100

ST303

47

113660

27

116583

20

2

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Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
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Parent Item: D407-802-011

Parent Item Name: Crew Door Opener Installation, LH

Start Date: 5/19/2011

Required Date: 5/19/2011

Start Qty: 1.00

Required Qty: 1.00

NAS1149C0532R

Purchased

No

105

Each

348.0000

6

6



WASHER



SP

Location

Loc Qty

Loc Code

ST297

348

116289

48

116373

100

116513

200

6

NAS1149C0563R

Purchased

No

105

Each

574.0000

6

6



Washer



11/5/19

Location

Loc Qty

Loc Code

ST297

574

112532

100

115768

74

116391

200

117460

200

6

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DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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5.0 PARTS LIST

5.1 D407-802-011/-012 Crew Door Opener Kits

Qty -011	Qty -012	Part Number	Description
		D407-802-011	CREW DOOR OPENER KIT, LH
		D407-802-012	CREW DOOR OPENER KIT, RH
1	1	D3552-15	DOOR PROP
2	2	D3622-5	BALL STUD
1		D4106-1	SILL DOUBLER, LH
	1	D4106-2	SILL DOUBLER, RH
1		D4106-3	CREW DOOR DOUBLER, LH
	1	D4106-4	CREW DOOR DOUBLER, RH
1	1	D4106-5	SPACER, SILL DOUBLER
1	1	D4106-7	TEMPLATE
26	26	CR3523-4-2	RIVET
4	4	CR3523-4-4	RIVET
3	3	CR3523-4-5	RIVET
8	8	CR3523-4-6	RIVET
7	7	CR3523-4-7	RIVET
4	4	MS20426AD4-5	RIVET
2	2	MS21073L5	ANCHOR NUT
6	6	NAS1149C0532R	WASHER
6	6	NAS1149C0563R	WASHER

